

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 10839 (1984): Jewelers' Saw [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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**AMENDMENT NO. 1 MAY 1996
TO
IS 10839 : 1984 SPECIFICATION FOR
JEWELLERS' SAW**

(*Page 1, clause 5.2, line 1*) — Substitute 'IS 620 : 1985 Wooden tool handles — General requirements (*fourth revision*)' for 'IS : 620 - 1975 General requirements for wooden tool handles (*third revision*)'.

(*Page 2, clause 9.1, line 2*) — Substitute 'IS 2500 (Part 1) : 1992 Sampling inspection procedures : Part 1 Attribute sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection (*second revision*)' for 'IS : 2500 (Part 1) - 1973 Sampling inspection tables: Part 1 Inspection by attributes and by count of defects (*first revision*)'.

(*Page 2, clauses 9.2 and 9.3, line 2*) — Substitute 'Tables I and II-A of IS 2500 (Part 1) : 1992' for 'Tables 1 and 2 of IS : 2500 (Part 1) - 1973'.

(PE 06)

Reprography Unit, BIS, New Delhi, India

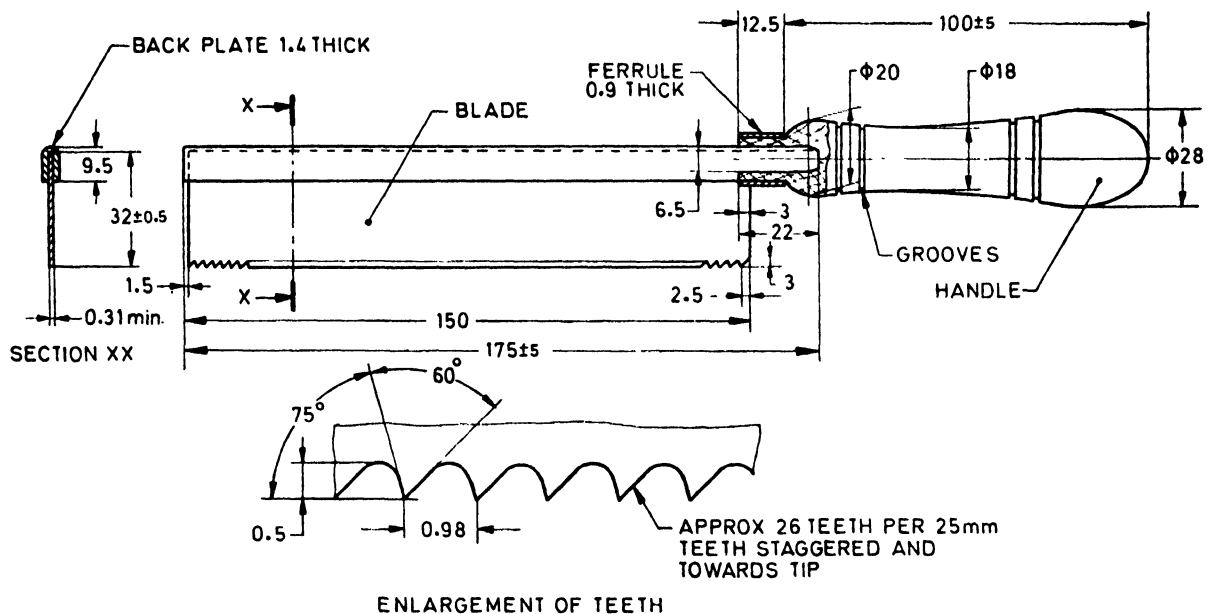


Indian Standard

SPECIFICATION FOR
JEWELLERS' SAW

1. **Scope** — Specifies the requirements of jewellers' saw.

2. **Dimensions** — Dimensions shall be as given in Fig. 1.



All dimensions in millimetres.

FIG. 1 DIMENSIONS FOR JEWELLERS' SAW

3. Material

Component	Material
Blade	Carbon steel — conforming to Designation T-90 of Schedule VI of IS : 1570-1961 'Schedules for wrought steels for general engineering purposes.
Black plate and ferrule	Brass sheet conforming to IS : 410-1977 'Cold-rolled brass sheet, strip and foil (third revision)

4. **Hardness** — The blade shall have hardness between 450 to 550 *HV* (\approx 45 to 50 *HRC*).

5. Manufacture

5.1 Blade shall be soundly forged, pressed or rolled to the shape and design as shown in Fig. 1. Teeth shall be accurately cut, properly staggered and towards the tip. The blade shall be suitably and evenly hardened and tempered throughout.

5.2 The handle shall be according to class 5 of IS : 620-1975 'General requirements for wooden tool handles (third revision)' and shall be made to the shape as shown in Fig. 1. It shall be thoroughly soaked in hot raw linseed for one hour and allowed to drain. It shall then be wiped clean with a dry piece of cloth.

5.3 The ferrule, formed to the shape with the meeting ends soundly brazed together, shall be fitted tightly to the handles in position. The handles shall be then securely fitted to the tangs of the blade.

Adopted 19 January 1984

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IS : 10839 - 1984

6. Workmanship and Finish

6.1 The blade and back plate with the tang shall be free from cracks, seams, scales, burrs and other manufacturing defects. These shall be finished smooth and bright all over. Teeth of the blade shall be full and properly sharpened, ground ready for immediate use. The handle shall be smoothly finished and varnished all over.

7. Marking

7.1 Each jewellers' saw, shall be clearly stamped on the blade with the size, manufacturer's name, initials or recognised trade-mark, and the year of manufacture.

7.2 *ISI Certification Marking* — Details available with the Indian Standards Institution.

8. Packaging — Preservation and packaging of the jewellers' saw, and marking on the packages shall be in accordance with the prevalent trade practice or as agreed between the manufacturer and the purchaser.

9. Sampling

9.1 In order to ascertain the conformity of a lot, the procedure for sampling inspection as given in IS : 2500 (Part 1)-1973 ' Sampling Inspection tables, Part 1 Inspection by attributes and by count of defects (*first revision*)' shall be followed. The inspection Level and Acceptance Quality Level (AQL) for various characteristics shall be according to **9.2** and **9.3**.

9.2 For dimensions as well as workmanship and finish, a single sampling plan with Inspection Level IV and AQL of 4 percent given in Tables 1 and 2 of IS : 2500 (Part 1)-1973, shall be followed.

9.3 For hardness and other requirements, a single sampling plan with Inspection level IV and AQL of 1.5 percent as given in Tables 1 and 2 of IS : 2500 (Part 1)-1973, shall be followed.

EXPLANATORY NOTE

While preparing this specification, considerable assistance has been derived from the Joint Services specification JSS-5110-22 'Saw, Backed, Jewellers, 150 mm length' issued by Ministry of Defence, Government of India.